

Work Order ID 164883

164883

Page 1

Tuesday, August 08, 2017 9:22:05 AM

Today

Item ID: D350-588-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017 Start Qty: 1.00

1
1

[Signature]

Cust Item ID:

Required Date: 8/8/2017 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: AUG 08 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-588	D								
DSI9690	A								
DSI9760-011	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-588-011 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

SnD

DAS
28
26
9-89

AUG 08 2017

2

[Signature]

AUG 08 2017

DAS
26
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 164883***164883***

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Tuesday, August 08, 2017 9:22:05 AM

Item ID: D350-588-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/8/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.03

Quality Control

2 DAS
28
9-89

AUG 08 2017

130 Identify as per dwg & Stock Location: _____ 0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-588-011
Location :FG0222 DAS
28
9-89

AUG 08 2017

140 QC21- Final Inspection - Work Order Release _____ 0.00

140

QC

Memo

0.10

Quality Control

DAS
21
9-89

AUG 09 2017



AUG 09 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						OTHER : ☐	

Picklist Print

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Page 1

Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:M04.08.31Added D2690-17KJ/JLM IPP REV:G
14.04.28 AS PER DSI9690 DD VERF:JLM IPP RevH 17-06-01 DSI
9760-011 DP VerifyDD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

115.0000

2

24

AN526C1032R7

Screw

AUG 08 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST326

115

M128403

115

24X

AN526C832R8

Purchased

No

120

Each

182.0000

8

8/14

AN526C832R8

Screw

AUG 08 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST327

182

m135978

82

m137597

100

8/14

AN526C832R9

Purchased

No

120

Each

296.0000

8

8/14

AN526C832R9

Screw

AUG 08 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST327

296

M136983

21

M137597

150

M138237

125

8/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
NO QA									
NO QA								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : _____			

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Page 2

Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

D2143

Manufactured No

120

Each

36.0000

D2143
Hinge Bracket

**

1 1

AUG 08 2017

DAS 26 9-89

DAS 28 9-89

Location	Loc Qty	Loc Code
ST002	36	
121806	5	
141033	1	
150285	8	
152427	10	
156245	12	

D2144

Manufactured No

120

Each

37.0000

D2144
Hinge Doubler

**

1 1

AUG 08 2017

DAS 26 9-89

DAS 28 9-89

Location	Loc Qty	Loc Code
ST002	23	
114332	4	
141066	1	
150971	18	
ST012a	14	
156274	14	

D2150

Manufactured No

120

Each

47.0000

D2150
Packer Doubler, Hinge

**

2 2

AUG 08 2017

DAS 26 9-89

DAS 28 9-89

Location	Loc Qty	Loc Code
ST002	27	
152300	15	
161768	12	
ST012a	20	
156276	20	

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Shop Packet Print

Page 2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

Picklist Print

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Page 3

Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

D2151 Manufactured No

120 Each

42.0000

D2151
Packer Doubler

** 2x B121825 AUG 8 2017 DAS 26 9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
ST002	22	
141044	2	
152281	20	
ST012a	20	
156257	20	

D2153 Manufactured No

120 Each

49.0000

D2153
Door Prop

** 1x B118894 AUG 8 2017 DAS 26 9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
ST362	49	
158104	13	
161471	36	

D2154 Manufactured No

120 Each

27.0000

D2154
Bracket, Stud

** 1x B118894 AUG 8 2017 DAS 26 9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
ST002	27	
145373	9	
152222	10	
156214	8	

D2237 Manufactured No

120 Each

45.0000

D2237
Striker Plate

** 2x B136090 AUG 8 2017 DAS 26 9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
ST004	45	
154292	15	
161662	30	

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Picklist Print

Tuesday, August 08, 2017 9:22:04 AM

Page 4

Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

D2461 Manufactured No 120 f

291.5035 7.25 7.631579

**

AUG 08 2017

DAS 26 9-89

D2461

Neoprene 'D' Seal (\$Per Foot)

DAS 38 9-89

Location

Loc Qty

Loc Code

ST407

291.5035433

291.503543

144533

~~87.00~~ 7.631579x2

cut 1 X 87.00"

D2463 Manufactured No 120 f

427.7418 7.25 7.631579

**

AUG 08 2017

DAS 26 9-89

D2463

1/2" Seal (\$ per foot)

Location

Loc Qty

Loc Code

ST409

427.7418270

140013

3.9081E-05

148875

0.00547229

160119

427.736316

~~87.00~~ 7.631579x2

cut 1 X 87.00"

D2583 Manufactured No 120 Each

25.0000

**

AUG 08 2017

DAS 26 9-89

D2583

Latch Bracket

Location

Loc Qty

Loc Code

ST481

25

161776

15

162483

10

24

DAS 28 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause				FAULT CATEGORY																					
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Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

D2585 Manufactured No

120 Each

59.0000

D2585
Latch Clamp

**

AUG 8 2017

DAS
26
9-89

Location	Loc Qty	Loc Code
ST008	59	
139075	10	
152476	9	
<u>156309</u>	4	
161798	18	
162498	18	

D2587 Manufactured No

120 Each

21.0000

D2587
Door Plug

**

AUG 8 2017

DAS
26
9-89

Location	Loc Qty	Loc Code
ST008	21	
<u>154216</u>	1	
<u>156256</u>	10	
161742	10	

D2589 Manufactured Yes

120 Each

29.0000

D2589
Keys, Key Chain

**

AUG 8 2017

DAS
26
9-89

Location	Loc Qty	Loc Code
ST008	29	
<u>132942</u>	29	

DAS
28
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Tuesday, August 08, 2017 9:22:04 AM

Page 6

Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

D2690-17

Manufactured No

120

Each

24.0000

D2690-17

Cable

DAS
28
9-89

Location

Loc Qty

Loc Code

ST009

4

150107

4

ST012a

20

152174

10

156171

10

D2857-1

Manufactured No

120

Each

24.0000

D2857-1

Hinge Bracket

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

144748

1

150331

3

91914

1

ST012

19

133964

4

141046

1

152448

14

** 1 12

12 rd

AUG 8 2017 26 9-89

** 1 12

12 rd

AUG 8 2017 26 9-89

12 rd

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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OTHER : _____																																																																							

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Page 7

Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

D2857-2 Manufactured No 120 Each 34.0000

D2857-2

Hinge Bracket

**

AUG 8 2017

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	9	
140972	2	
152184	7	
ST012	13	
133903	4	
140972	1	
152184	8	
ST012a	12	
161675	12	

D2858-1 Manufactured No 120 Each 28.0000

D2858-1

Hinge Bracket

**

AUG 8 2017

DAS
28
9-89

Location	Loc Qty	Loc Code
ST012	24	
152740	12	
162847	12	
ST012a	4	
156173	4	

D2858-2 Manufactured No 120 Each 21.0000

D2858-2

Hinge Bracket

**

AUG 8 2017

DAS
28
9-89

Location	Loc Qty	Loc Code
FG	2	
77020	2	
ST012	19	
152277	19	

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Page 7

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

D5080-041 Manufactured No 120 Each 12.0000

D5080-041

Striker Plate Assembly

DAS
28
9-89

Location

Loc Qty

Loc Code

ST148

12

152250

12

120

Each

0.0000

D5275-041

Manufactured No

D5275-041

Door Latch Assembly

DAS
28
9-89

FG-778150-550-ROL

Purchased No

FG-778150-550-ROI

7781 9 oz Glass 50" x 125 yd

Location

Loc Qty

Loc Code

CA2

388.5000450

M127701

4.4850E-05

M134550

388.500000

st417

132

M134550

132

1- cut 1 square ft of glass cloth

MS20426AD3-4

Purchased No

MS20426AD3-4

RIVET

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

5644

m134294

1921

m136444

3723

ST312

1550

m134294

1550

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Work Order update only

Work Order: _____ Part No. _____ NCR No: _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
1001 1002 1003 1004 1005 1006 1007 1008 1009 1010 1011 1012 1013 1014 1015 1016 1017 1018 1019 1020 1021 1022 1023 1024 1025 1026 1027 1028 1029 1030 1031 1032 1033 1034 1035 1036 1037 1038 1039 1040 1041 1042 1043 1044 1045 1046 1047 1048 1049 1050 1051 1052 1053 1054 1055 1056 1057 1058 1059 1060 1061 1062 1063 1064 1065 1066 1067 1068 1069 1070 1071 1072 1073 1074 1075 1076 1077 1078 1079 1080 1081 1082 1083 1084 1085 1086 1087 1088 1089 1090 1091 1092 1093 1094 1095 1096 1097 1098 1099 1100 1101 1102 1103 1104 1105 1106 1107 1108 1109 1110 1111 1112 1113 1114 1115 1116 1117 1118 1119 1120 1121 1122 1123 1124 1125 1126 1127 1128 1129 1130 1131 1132 1133 1134 1135 1136 1137 1138 1139 1140 1141 1142 1143 1144 1145 1146 1147 1148 1149 1150 1151 1152 1153 1154 1155 1156 1157 1158 1159 1160 1161 1162 1163 1164 1165 1166 1167 1168 1169 1170 1171 1172 1173 1174 1175 1176 1177 1178 1179 1180 1181 1182 1183 1184 1185 1186 1187 1188 1189 1190 1191 1192 1193 1194 1195 1196 1197 1198 1199 1200 1201 1202 1203 1204 1205 1206 1207 1208 1209 1210 1211 1212 1213 1214 1215 1216 1217 1218 1219 1220 1221 1222 1223 1224 1225 1226 1227 1228 1229 1230 1231 1232 1233 1234 1235 1236 1237 1238 1239 1240 1241 1242 1243 1244 1245 1246 1247 1248 1249 1250 1251 1252 1253 1254 1255 1256 1257 1258 1259 1260 1261 1262 1263 1264 1265 1266 1267 1268 1269 1270 1271 1272 1273 1274 1275 1276 1277 1278 1279 1280 1281 1282 1283 1284 1285 1286 1287 1288 1289 1290 1291 1292 1293 1294 1295 1296 1297 1298 1299 1300 1301 1302 1303 1304 1305 1306 1307 1308 1309 1310 1311 1312 1313 1314 1315 1316 1317 1318 1319 1320 1321 1322 1323 1324 1325 1326 1327 1328 1329 1330 1331 1332 1333 1334 1335 1336 1337 1338 1339 1340 1341 1342 1343 1344 1345 1346 1347 1348 1349 1350 1351 1352 1353 1354 1355 1356 1357 1358 1359 1360 1361 1362 1363 1364 1365 1366 1367 1368</									

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Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

120

Each

1,356.000

18 36
**

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

644

m136851

644

ST310

712

~~m136851~~

712

120

Each

807.0000

18 36 al
18 36 ul
**

AUG 08 2017
DAS 26 9-89

MS21042L08

Purchased

No

MS21042L08

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

94

m135978

94

ST303

713

m137736

42

m137951

200

m138045

146

~~m138207~~

125

m138237

200

18 36 ul

AUG 08 2017
DAS 26 9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
1234567890								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, August 08, 2017 9:22:05 AM

Page 10

Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

120

Each

2,166.000

MS21042L3

Nut

**

AUG 08 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

350

m134360

102

M136665

248

OVER007

500

m138230

500

ST303

1237

m137988

237

m138084

1000

MS27039-08-11

Purchased

No

120

Each

178.0000

MS27039-08-11

SCREW

**

AUG 08 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

ST278

178

m135864

4

m137412

174

MS27039-1-15

Purchased

No

120

Each

148.0000

MS27039-1-15

Screw

**

AUG 08 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

47

m127916

1

m136554

46

ST280

101

m136406

1

m137886

100

Tuesday, August 08, 2017 9:22:05 AM

Shop Packet Print

Page 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, August 08, 2017 9:22:05 AM

Page 11

Work Order ID: 164883

164883

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017

Required Date: 8/8/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-17

Purchased

No

120

Each

136.0000

2

MS27039-1-17

Screw (601.1954)

**

AUG 08 2017

DAS 26 9-89

Location

Loc Qty

Loc Code

ST280

136

m127831

136

Each

116.0000

**

AUG 08 2017

DAS 26 9-89

MS27039-1-25

Purchased

No

MS27039-1-25

Screw

Location

Loc Qty

Loc Code

over006

100

m127432

100

ST279

16

102602

16

120

Each

942.0000

**

AUG 08 2017

DAS 26 9-89

NAS1149D0363J

Purchased

No

NAS1149D0363J

Washer

Location

Loc Qty

Loc Code

GA

620

m134055

13

m137164

15

m137963

592

ST263

322

m137587

11

m137963

311

120

Each

1,930.0000

**

AUG 08 2017

DAS 26 9-89

NAS1149DN832J

Purchased

No

NAS1149DN832J

Washer

Location

Loc Qty

Loc Code

ST264

1930

M137587

1930

DAS 28 9-89

Tuesday, August 08, 2017 9:22:05 AM

Shop Packet Print

Page 11

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-588 REV. D AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-588 REV. 0 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-41

REF. FAA STC: SH1012NE

AND TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-41

REF. FAA STC: SH1012NE

AND TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-600 REV. E AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-600 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH93-88

REF. FAA STC: SR00098NY/SR00099NY

REF. EASA STC: EASA.IM.R.S.01292

AND TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER APPROVED REVISION

REF. TCCA STC: SH93-88

REF. FAA STC: SR00098NY

REF. EASA STC: EASA.IM.R.S.01292

1.0 PURPOSE

The purpose of this Service Instruction is to address customer concerns with leaking water around the D2586 Latch. The DSI 9760-011/-013 kits include weatherproof latches and associated hardware to replace the existing D2586 latches at the customer's option. This DSI applies to the following Dart kits:

AIRCRAFT MODEL	DART KIT	DSI KIT REQ'D
EC130 SHOP SERIES RETURN TO ENGINEERING UNCONTROLLED CONDITION SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 16488234 AUG 08 2017 AS 350/355 SERIES	D130-780-043 (INCLUDED IN D130-780-041)	DSI 9760-011
	D130-780-044 (INCLUDED IN D130-780-042)	DSI 9760-011
	DSI 9189-011	DSI 9760-011
	D350-588-041	DSI 9760-011
	D350-588-011	DSI 9760-011
	D350-589-011	DSI 9760-013
	D350-589-041	DSI 9760-013
	D350-589-042	DSI 9760-013
	D355-589-043	DSI 9760-013
	D350-600-145 (INCLUDED IN D350-600-141 AND D355-600-143)	DSI 9760-013
	D350-600-146 (INCLUDED IN D350-600-142)	DSI 9760-013
	D350-600-245 (INCLUDED IN D350-600-241 AND D355-600-243)	DSI 9760-011
	D350-600-246 (INCLUDED IN D350-600-242)	DSI 9760-011

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 16.10.04
CERT. NO.: SH93-88/SH92-41
ISSUE NO.: 6/8

APPROVED

A	NEW ISSUE	VS	16.10.04
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9760	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEATHERPROOF LATCH	NTS
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2.0 INSTALLATION

- 2.1 Remove the D2585/D2588 Mounting Channels, D2621 Latch Plates and associated hardware per Figure 1. Retain the D2585/D2588 Mounting Channels and D2621 Latch Plates. Remove the D2586 Latches.
- 2.2 Install the D5275-041 Door Latch Assys in existing mounting hole using hardware shown in Figure 1 and the retained parts for step 2.1. Torque MS21042L3 Nuts to 15-25 in-lb (1.7-2.8 N-m). Adjust screws to ensure compression of door seal and lock in position with nuts. Check latches for proper operation by opening and closing the door and latches several times.
- 2.3 Update aircraft logbook to indicate installation of the DSI 9760-011/-013 Weatherproof Latch kit as applicable.

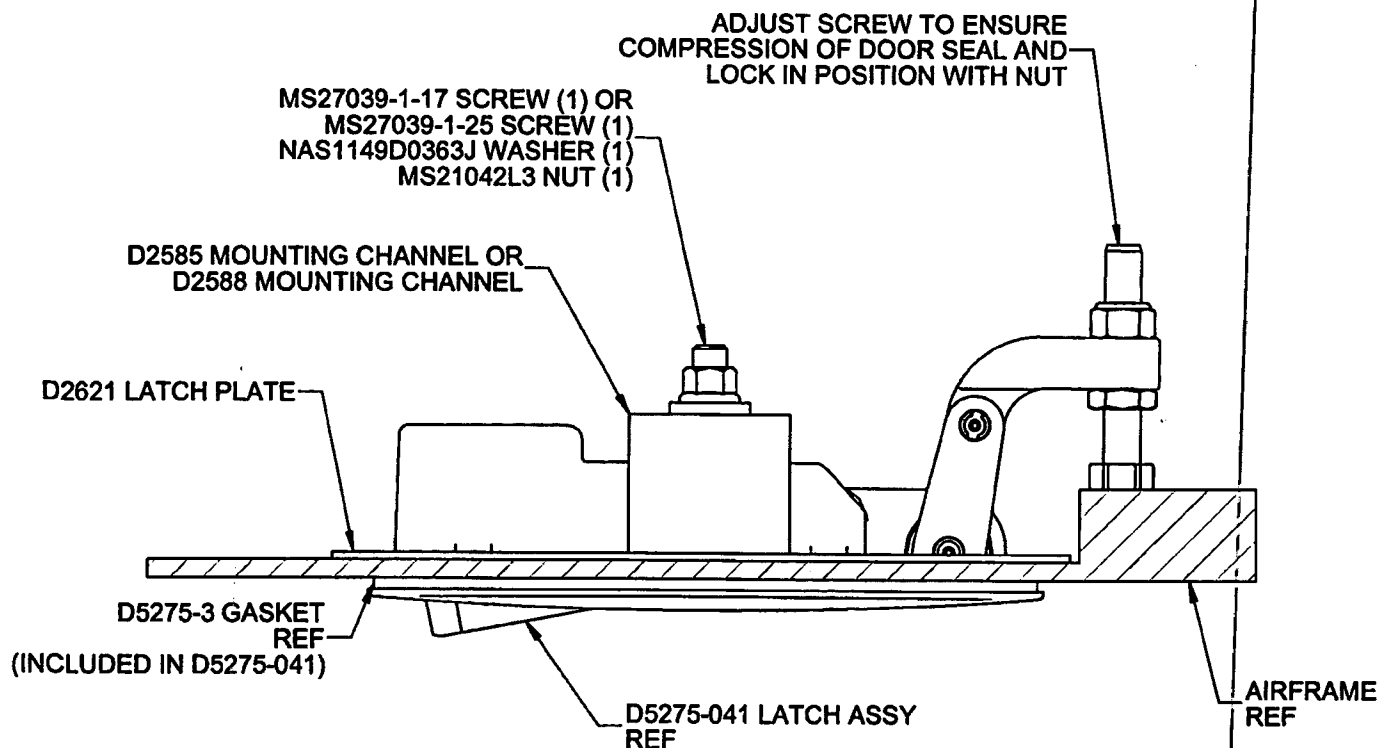


Figure 1 - Door Latch Installation and Removal

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DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9760	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEATHERPROOF LATCH	NTS
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3.0 MAINTENANCE

Maintain D5275-041 Latch Assy per the applicable Instructions for Continued Airworthiness (ICA) for the D2586 Latch.

4.0 WEIGHT AND BALANCE

This change has negligible effect on Weight and Balance.

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9760-011	WEATHERPROOF LATCH KIT
	X	DSI 9760-013	WEATHERPROOF LATCH KIT
2	3	D5275-041	DOOR LATCH ASSY
2	3	MS27039-1-17	SCREW
2	3	MS27039-1-25	SCREW
2	3	NAS1149D0363J	WASHER
2	3	MS21042L3	NUT

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9760	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEATHERPROOF LATCH	NTS
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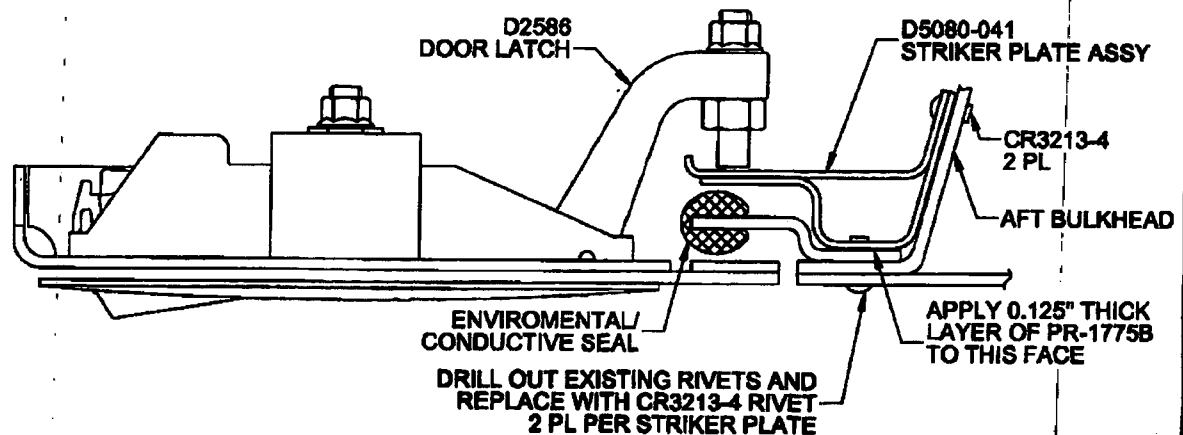
SHOP COPY

RETURN TO
ENGINEERING**DART SERVICE INSTRUCTION**TO AMEND INSTALLATION INSTRUCTIONS D350-588 REV. D AND CONTROLLED COPY
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-588 REV. 0 TO AMENDMENTREF TCCA STC SH92-41
FAA STC SH1012NEWITHOUT NOTICE
WORK ORDERNO. 164283
AUG 08 2017**1.0 PURPOSE:**

The purpose of this Dart Service Instruction is to provide customers with directions to install a modified striker plate that will provide more clearance around environmental/conductive seals that protrude inboard of the door frame structure on AS355 N/NP models.

2.0 PROCEDURE:

- 1) Install D350-588-011/-041 per Section 3.1/3.2 of D350-588 as applicable, except do not install D2237 striker plates per item 10 of Section 3.1.
- 2) Remove the aft environmental/conductive seal to gain access to the door structure.
- 3) Using a fine point marker, mark location of both striker plates based on door latch location.
- 4) If D2237 Striker Plates are currently installed, remove both striker plates by drilling out rivets.
- 5) Align D5080-041 striker plate assembly in the previously marked location and transfer drill the $\varnothing 0.1285"$ (#30) holes into the aft bulkhead.
- 6) Drill out both rivets on the aircraft skin adjacent to the striker plate assemblies.
- 7) Align D5080-041 striker plate assembly in the previously marked location and transfer drill the $\varnothing 0.1285"$ (#30) holes from the aircraft skin to the striker plate assembly.
- 8) Deburr holes and remove all sharp edges.
- 9) Touch up all holes in aluminum with chemical conversion coating in accordance with MIL-DTL-5541.
- 10) Apply 0.125" thick layer of PR-1775B ProSeal to the face of D5080-041 per Figure 1.
- 11) Install D5080-041 striker plate assemblies to the aft bulkhead using CR3213-4 rivets of a suitable length, and to the skin of the aircraft using PR-1775B coated CR3213-4 rivets of a suitable length.
- 12) Reinstall environmental/conductive seal using manufacturers recommended procedure.
- 13) Install gas strut or cable assembly per D350-588 Figure 5.
- 14) Adjust both latch mechanisms to ensure adequate compression of door seal and that door skin is flush.
- 15) Check door for proper operation by opening and closing the door, and ensure latches fully lock.

**Figure 1 Striker Plate**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-Q-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

A	NEW ISSUE	ML	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	N/A	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 1 OF 2
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	STRIKER PLATE MOD	NTS
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3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH82-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE MOD	NTS
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Today

Work Order ID 164883

164883

Tuesday, August 08, 2017 9:22:05 AM

Item ID: D350-588-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Fwd Hinge Modification

Start Date: 8/8/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/8/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date: AUG 08 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D350-588	D
----------	---

DSI9690	A
---------	---

DSI9760-011	A
-------------	---

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

DAS

5

9-89

AUG 08 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

REFERENCE ONLY

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH82-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	NTA	DSI 9690	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE MOD	NTS
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REFERENCE ONLY

3.0 MAINTENANCE

Maintain D5275-041 Latch Assy per the applicable Instructions for Continued Airworthiness (ICA) for the D2586 Latch.

4.0 WEIGHT AND BALANCE

This change has negligible effect on Weight and Balance.

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9760-011	WEATHERPROOF LATCH KIT
	X	DSI 9760-013	WEATHERPROOF LATCH KIT
2	3	D5275-041	DOOR LATCH ASSY
2	3	MS27039-1-17	SCREW
2	3	MS27039-1-25	SCREW
2	3	NAS1149D0363J	WASHER
2	3	MS21042L3	NUT

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9760	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEATHERPROOF LATCH	NTS
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